Inspiring the future generations of welders

Product
Data Sheet

DuraMax E71T-1 Flux Cored Wire DM71TGS

Classification: **E71TGS** **AWS A5.20 / ASME SFA 5.20**

Description, Characteristics & Applications:

DuraMax E71TGS is a self-shielded flux cored wire for lap and fillet welds of mild and medium tensile steels not exceeding 510MPa. It is suitable for a variety of applications such as prefab, building fabrication, tanks, ornamental iron, farm implement, repairs and general fabrication.

CHARACTERISTICS ON USAGE:

1- Wire is for all-positional welding of single pass automatic and semiautomatic fabrications.
2- It can be applicable for aluminized steel and galvanized steel from 1.2 to 5.0mm.
3- It is designed for on-site general fabrication and structural work requiring no impact properties.
4- It can be used DCEN polarity.

Typical Chemical Composition (%)

C	Mn	Si	P	S	Cr	Ni	Mo	Al	Cu
0.10 – 0.30	0.40 – 0.90	0.20 - 0.50	≤ 0.20	≤ 0.020	≤ 0.10	≤ 0.10	≤ 0.10	1.20 – 1.70	≤ 0.10

Typical Mechanical Properties as Welded

	Tensile Strength	Yield Strength	Elongation (%)	Hardness	Ferrite WRC (FN)	CVN Impacts (J) @ °C
AWS	490 min	390 min	22 min	-------	-------	-------
Typical Values	540	540	25	-------	-------	-------

Diameter	0.030	0.035	0.045
Polarity	DC-	DC-	DC-
Shielding Gas Used	-------	-------	-------
Voltage (V)	15	17	18
Wire Feed Speed (in/min)	200	160	100
Current (A)	100	115	160
Preheat Temp °C (F)	150 (300)	150 (300)	150 (300)

NOTE: Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

POLARITY: DCEP or AC
DCEP = DC, Electrode Positive (reverse polarity) has the most weld penetration.
AC: medium weld penetration (can have more spatter)
WELDING POSITIONS: All Positions
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METAL

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